

Date: Friday, 04/01/2008 7:26:06 AM  
User: Linda Lacaille

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BLADE FOLD KIT  
Job Number : 35372  
Estimate Number : 10787  
P.O. Number :  
This Issue : 04/01/2008 S.O. No. :  
Prsht Rev. : NC  
First Issue : 25/10/2007 Type : PURCHASED PARTS  
Previous Run : 29657  
Written By :  
Checked & Approved By :  
Comment : Est A 05/08/30 New Issue KJ/MB/JLM

Part Number : D412695011  
Drawing Number : B67-43001 REV B  
Project Number : N/A  
Drawing Revision : B  
Material :  
Due Date : 23/12/2007 Qty: 2 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-695-011 CHG002

2.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

SANDEX GREEN PER QSI005  
PARTS BELOW WHERE APPLICABLE

M102316

INSPECT POWDER COAT/CHEMICAL CONVERSION

3.0 QC3



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

4.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

3 36953 = 1 WORK

5.0 PB6743001261 Lever Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000-Each(s)

Lever Arm

Pick: Fwd Assembly


Qty: Part Number Description Batch  
2 B67-43001-261 Lever Arm

10537 2008/1/28

NR

NOTE: DATE  
H-I-FORMS/Quality Assurance/Process

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08-01-16	4.	Install rivet ms20426 AD3-5 # <u>m4179</u> & nutplates. MS21075 L3E # <u>m106831</u> .	mf	08-01-16		 08.01.79	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

to & initial all entries

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Part Number: D412695011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001261

Lever Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Lever Arm

Pick: Fwd Assembly

Qty Part Number Description Batch

2 B67-43001-261 Lever Arm 24011/10537 min 2008 1.1/28

7.0

PB6743001265

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Pick: Fwd Assembly

Qty Part Number Description Batch

4 B67-43001-265 Bushing 10537 36883 min 2008 1.1/29 (8)

8.0

PB6743001299

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bushing

Pick: Fwd Assembly

Qty Part Number Description Batch

2 B67-43001-299 Bushing 10537 24017 min 2008 1.1/28

9.0

D3445041

Belt Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Belt Assembly

Pick: Fwd Assembly

Qty Part Number Description Batch

1 D3445-041 Belt Assembly 24243 18244 AS 08/01/11 (x2)

10.0

D34473

Square Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Square Spacer

Pick: Fwd Assembly

Qty Part Number Description Batch

2 D3447-3 Square Spacer B24416 1327372 AS 08/01/11 (x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Seq. #:

Machine Or Operation:

Description :

11.0

D34475

Clevis



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Clevis

Pick: Fwd Assembly

Qty Part Number Description Batch

2 D3447-9 Swing Arm

35549 x 1 min 2008/1/30

23989 x 3

AS 08/01/11

(X2)

12.0

D34479

Swing Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Swing Arm

Pick: Fwd Assembly

Qty Part Number Description Batch

2 D3447-9 Swing Arm

B36267

min 2008/1/29 (4)

13.0

AN410A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Pick: Fwd Assembly

Qty Part Number Description Batch

2 AN4-10A Bolt

105442

AS 08/01/11

(X2)

14.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Pick: Fwd Assembly

Qty Part Number Description Batch

2 AN4-13A Bolt

106513

AS 08/01/11

(X2)

15.0

AN416A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Pick: Fwd Assembly

Qty Part Number Description Batch

4 AN4-16A Bolt

M18949

AS 08/01/11

(X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D412695011

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Seq. #:

Machine Or Operation:

Description :

16.0

AN611A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Pick: Fwd Assembly

Qty	Part Number	Description	Batch
2	AN6-11A	Bolt	M105558.

M105558.

AS

08/01/11 (X2)

17.0

AN620A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Pick: Fwd Assembly

Qty	Part Number	Description	Batch
2	AN6-20A	Bolt	M104547.

M104547.

AS

08/01/11 (X2)

18.0

AN813A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Pick: Fwd Assembly

Qty	Part Number	Description	Batch
2	AN8-13A	Bolt	18180.

18180.

AS

08/01/11 (X2)

19.0

AN960JD6

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Pick: Fwd Assembly

Qty	Part Number	Description	Batch
2	AN960JD6	Washer	6085.

6085.

AS

08/01/11 (X2)

20.0

BSP43

RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

RIVET

Pick: Fwd Assembly

Qty	Part Number	Description	Batch
4	BSP43	Rivet	M17890

M17890

AS

08/01/11 (X2)

W/O:		WORK ORDER CHANGES					
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Seq. #:	Machine Or Operation:	Description :
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21.0	CR3213405	cherry rivet
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Cherry Rivert

Pick: Fwd Assembly

Qty	Part Number	Description	Batch
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2	CR3213-4-05	Cherry Rivet	M10424
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AS 08/01/11

(x2)

22.0	MS17984C408	PIN, QUICK RELEASE
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

PIN, QUICK RELEASE

Pick: Fwd Assembly

Qty	Part Number	Description	Batch
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2	MS17984C408	Quick Release Pin	103641
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AS 08/01/11

(x2)

23.0	MS17984C418	PIN, QUICK RELEASE
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

PIN, QUICK RELEASE

Pick: Fwd Assembly

Qty	Part Number	Description	Batch
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2	MS17984C418	Quick Release Pin	M18591 x3 M106277 x1
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AS 08/01/11

(x2)

24.0	MS21042L3	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Pick: Fwd Assembly

Qty	Part Number	Description	Batch
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2	MS21042L3	Nut (or -3)	M105558
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AS 08/01/11

(x2)

25.0	MS21042L4	Nut
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut

Pick: Fwd Assembly

Qty	Part Number	Description	Batch
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8	MS21042L4	Nut (or -4)	M105054
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AS 08/01/11

(x2)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D412695011

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

MS21042L6

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Nut

Pick: Fwd Assembly

Qty	Part Number	Description	Batch
4	MS21042L6	Nut (or -6)	M104374

AS 08/01/11 (K2)

27.0

MS27039104

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Screw

Pick: Fwd Assembly

Qty	Part Number	Description	Batch
2	MS27039-1-04	Screw	M18431

AS 08/01/11 (K2)

28.0

MS27039123

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)  
SCREW

Pick: Fwd Assembly

Qty	Part Number	Description	Batch
2	MS27039-1-23	Screw	18057

AS 08/01/11 (K2)

29.0

MS518596

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)  
WASHER

Pick: Fwd Assembly

Qty	Part Number	Description	Batch
8	MS51859-6	Washer	M17890 x12 M106277 x4

AS 08/01/11 (K2)

30.0

MS518598

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)  
WASHER

Pick: Fwd Assembly

Qty	Part Number	Description	Batch
8	MS51859-8	Washer	M18854

AS 08/01/11 (K2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 35372

Part Number: D412695011

Job Number:



Seq. #: Machine Or Operation: Description :

31.0 NAS43DD368 SPACER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)  
SPACER

Pick: Fwd Assembly

Qty Part Number Description Batch  
2 NAS43DD3-68 Spacer

B102050

AS 08/01/11

(X2)

32.0 NAS1149F0316P WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)  
WASHER

Pick: Fwd Assembly

Qty Part Number Description Batch  
4 NAS1149F0316P Washer

17890 x1 M106242 x7

AS 08/01/11

(X2)

33.0 NAS1149F0432P Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total: 32.0000 Each(s)  
Washer

Pick: Fwd Assembly

Qty Part Number Description Batch  
16 NAS1149F0432P Washer

M18057

AS 08/01/11

(X2)

34.0 NAS1149F0632P WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)  
WASHER

Pick: Fwd Assembly

Qty Part Number Description Batch  
8 NAS1149F0632P Washer

M18057

AS 08/01/11

(X2)

35.0 NAS1149F0832P WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)  
WASHER

Pick: Fwd Assembly

Qty Part Number Description Batch  
4 NAS1149F0832P Washer

M108057

AS 08/01/11

(X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 35372

Part Number: D412695011

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

086004

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Gripper Kit Fully Loaded

Pick: Fwd Assembly

Qty Part Number Description

Batch

2 086-004 Gripper Kit Fully Loaded

17850

AS 08/01/11

(x2)

37.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

SPRING SLOTTED PIN

Pick: Fwd Assembly

Qty Part Number Description

Batch

8 240-107 Ø1/8" x 1 1/8" Spring Slotted Pin

M102940

AS 08/01/11

(x2)

38.0

30345T22

8" LANYARD



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

8" LANYARD

Pick: Fwd Assembly

Qty Part Number Description Batch

2 30345T22 Lanyard

M102812

AS 08/01/11

(x2)

39.0

30345T24

LANYARDS



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

LANYARDS

Pick: Fwd Assembly

Qty Part Number Description

Batch

2 30345T24 Lanyard

M102812

A/R

242 Thread Lock

Assemble as per Dwg B67-43001-02 pg 2. (See prototype template)

AS 08/01/11

(x2)

40.0

PB6743001261

Lever Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Lever Arm

Pick: Aft Assembly

Qty Part Number Description Batch

2 B67-43001-261 Lever Arm

10537/24011  
min 2008/1/25

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 35372

Part Number: D412695011

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

PB6743001265

Bushing



Comment: Qty.: 5.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Aft Assembly

Qty Part Number

Description Batch

5

B67-43001-265

Bushing

B 36359 1X  
B 36892 9X

10537 min 2008/1/28

42.0

PB6743001299

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bushing

Pick: Aft Assembly

Qty

Part Number

Description

Batch

2

B67-43001-299

Bushing

24017/10537 min 2008/1/28

43.0

PB6743001305

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bearing

Pick: Aft Assembly

Qty

Part Number

Description

Batch

1

B67-43001-305 Bearing

10537 min 2008/1/28

44.0

D34401

Tube Guide



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Tube Guide

Pick: Aft Assembly

Qty

Part Number

Description

Batch

1

D3440-1

Tube Guide

B 23949

AS 08/01/11 (X2)

45.0

D34403

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp

Pick: Aft Assembly

Qty

Part Number

Description

Batch

1

D3440-3

Clamp

B 36266 X1

B 24019 x1

min 2008/1/30

AS 08/01/11 (X2)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

46.0

D34441

Velcro Loop Belt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Velcro Loop Belt

Pick: Aft Assembly

Qty Part Number Description Batch

1 D3444-1 Velcro Loop Belt

35548

AS

08/01/11

(K2)

47.0

D34479

Swing Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Swing Arm

Pick: Aft Assembly

Qty Part Number Description Batch

2 D3447-9 Swing Arm

23962

AS

08/01/11

(K2)

48.0

AN410A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Pick: Aft Assembly

Qty Part Number Description Batch

2 AN4-10A Bolt

104603

AS

08/01/11

(K2)

49.0

AN413A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick: Aft Assembly

Qty Part Number Description Batch

1 AN4-13A Bolt

106513

AS

08/01/11

(K2)

50.0

AN416A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Pick: Aft Assembly

Qty Part Number Description Batch

4 AN4-16A Bolt

M18949

AS

08/01/11

(K2)

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Part Number: D412695011

Job Number:



Seq. #:

Machine Or Operation:

Description :

51.0

AN526A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
BOLT

Pick: Aft Assembly

Qty	Part Number	Description	Batch
1	AN5-26A	Bolt	18057

AS 08/01/11 (K2)

52.0

AN611A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)  
BOLT

Pick: Aft Assembly

Qty	Part Number	Description	Batch
2	AN6-11A	Bolt	M18057 x1 M105558 x3

AS 08/01/11 (K2)

53.0

AN620A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Bolt

Pick: Aft Assembly

Qty	Part Number	Description	Batch
2	AN6-20A	Bolt	104547

AS 08/01/11 (K2)

54.0

AN813A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)  
BOLT

Pick: Aft Assembly

Qty	Part Number	Description	Batch
2	AN8-13A	Bolt	18180

AS 08/01/11 (K2)

55.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Washer

Pick: Aft Assembly

Qty	Part Number	Description	Batch
1	AN960JD6	Washer	M6085

AS 08/01/11 (K2)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

56.0

BSP43

RIVET



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)  
RIVET

Pick: Aft Assembly

Qty	Part Number	Description	Batch
3	BSP43	Rivet	M17890

AS 08/01/11 (42)

57.0

CR3213405

cherry rivet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Cherry Rivet

Pick: Aft Assembly

Qty	Part Number	Description	Batch
1	CR3213-4-05	Cherry Rivet	M104214

AS 08/01/11 (42)

58.0

MS17984C413

PIN, QUICK RELEASE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
PIN, QUICK RELEASE

Pick: Aft Assembly

Qty	Part Number	Description	Batch
1	MS17984C413	Quick Release Pin	M18119

AS 08/01/11 (42)

59.0

MS17984C418

PIN, QUICK RELEASE



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)  
PIN, QUICK RELEASE

Pick: Aft Assembly

Qty	Part Number	Description	Batch
3	MS17984C418	Quick Release Pin	M18591

AS 08/01/11 (42)

60.0

MS21042L4

Nut



Comment: Qty.: 9.0000 Each(s)/Unit Total : 18.0000 Each(s)  
Nut

Pick: Aft Assembly

Qty	Part Number	Description	Batch
9	MS21042L4	Nut (or -4)	M105054

AS 08/01/11 (42)

Date: Friday, 04/01/2008 7:26:06 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FOLD KIT

Job Number: 35372

Part Number: D412695011

Job Number:



Seq. #:

Machine Or Operation:

Description :

61.0

MS21042L5

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Pick: Aft Assembly

Qty Part Number Description Batch

1 MS21042L5 Nut (or -5) M105940

AS 08/01/11 (X2)

62.0

MS21042L6

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Pick: Aft Assembly

Qty Part Number Description Batch

4 MS21042L6 Nut (or -6) M104374

AS 08/01/11 (X2)

63.0

MS24694S100

FLAT HEAD SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

FLAT HEAD SCREW

Pick: Aft Assembly

Qty Part Number Description Batch

2 MS24694-S100 M18431

AS 08/01/11 (X2)

64.0

MS27039104

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Pick: Aft Assembly

Qty Part Number Description Batch

1 MS27039-1-04 Screw M18431

AS 08/01/11 (X2)

65.0

MS27039115

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Pick: Aft Assembly

Qty Part Number Description Batch

1 MS27039-1-15 Screw M104150

AS 08/01/11 (X2)

Date: Friday, 04/01/2008 7:26:06 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FOLD KIT

Job Number: 35372

Part Number: D412695011

Job Number:



Seq. #:

Machine Or Operation:

Description :

66.0

MS518596

WASHER



Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)  
WASHER

Pick: Aft Assembly

Qty Part Number Description Batch  
6 MS51859-6 Washer M17890

AS 08/01/11 (X2)

67.0

MS518597

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Washer

Pick: Aft Assembly

Qty Part Number Description Batch  
2 MS51859-7 Washer M11822

Same Batch for All 4

AS 08/01/11 (X2)

68.0

MS518598

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)  
WASHER

Pick: Aft Assembly

Qty Part Number Description Batch  
8 MS51859-8 Washer M18854

AS 08/01/11 (X2)

69.0

NAS43DD368

SPACER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
SPACER

Pick: Aft Assembly

Qty Part Number Description Batch  
1 AS43DD3-68 Spacer 102850

AS 08/01/11 (X2)

70.0

NAS1149F0316P

WASHER



Comment: Qty.: 5.0000 Each(s)/Unit Total : 10.0000 Each(s)  
WASHER

Pick: Aft Assembly

Qty Part Number Description Batch  
5 NAS1149F0316P Washer 17890

AS 08/01/11 (X2)

Date: Friday, 04/01/2008 7:26:06 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FOLD KIT

Job Number: 35372

Part Number: D412695011

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

71.0	NAS1149F0432P	Washer
------	---------------	--------



Comment: Qty.: 14.0000 Each(s)/Unit Total : 28.0000 Each(s)  
Washer

Pick: Aft Assembly

Qty	Part Number	Description	Batch
14	NAS1149F0432P	Washer	M18057

AS 08/01/11 (x2)

72.0	NAS1149F0532P	WASHER
------	---------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)  
WASHER

Pick: Aft Assembly

Qty	Part Number	Description	Batch
2	NAS1149F0532P	Washer	M18057

AS 08/01/11 (x2)

73.0	NAS1149F0632P	WASHER
------	---------------	--------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)  
WASHER

Pick: Aft Assembly

Qty	Part Number	Description	Batch
8	NAS1149F0632P	Washer	M18057

AS 08/01/11 (x2)

74.0	NAS1149F0832P	WASHER
------	---------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)  
WASHER

Pick: Aft Assembly

Qty	Part Number	Description	Batch
4	NAS1149F0832P	Washer	M18057

AS 08/01/11 (x2)

75.0	086004	Inventory
------	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Gripper Kit Fully Loaded

Pick: Aft Assembly

Qty	Part Number	Description	Batch
1	086-004	Gripper Kit Fully Loaded	17050

AS 08/01/11 (x2)

Date: Friday, 04/01/2008 7:26:06 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FOLD KIT

Job Number: 35372

Part Number: D412695011

Job Number:



Seq. #:

Machine Or Operation:

Description :

76.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 7.0000 Each(s)/Unit Total : 14.0000 Each(s)  
SPRING SLOTTED PIN

Pick: Aft Assembly

Qty Part Number Description

7 240-107 Ø1/8" x 1 1/8" Spring Slotted Pin

Batch

M102940

Assemble as per

Dwg B67-43001-03 pg 3. (See prototype template)

AS 08/01/11 (X2)

77.0

30345T21

LANYARD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
LANYARD

Pick: Aft Assembly

Qty Part Number Description Batch

1 30345T21 Lanyard

M102812

AS 08/01/11 (X2)

78.0

30345T22

8" LANYARD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
8" LANYARD

Pick: Aft Assembly

Qty Part Number Description Batch

1 30345T22 Lanyard

M102812

AS 08/01/11 (X2)

79.0

30345T24

LANYARDS



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)  
LANYARDS

Pick: Aft Assembly

Qty Part Number Description Batch

2 30345T24 Lanyard

M102812

AS 08/01/11 (X2)

80.0

3408A98

DETENT BALL SPRING PLUNG



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
DETENT BALL SPRING PLUNG

Pick: Aft Assembly

Qty Part Number Description Batch

1 3408A98 Detent Ball Spring Plunger

M102812

A/R 242 Thread Lock

Assemble as per Dwg B67-43001-03 pg 3. (See prototype template)

AS 08/01/11 (X2)



Date: Friday, 04/01/2008 7:26:06 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FOLD KIT

Job Number: 35372

Part Number: D412695011

Job Number:



Seq. #:

Machine Or Operation:

Description :

81.0

PB6743001289

Handle Adjustmnt Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle Adjustmnt Fitting

Pick: Blade Positioner

Qty Part Number Description

Batch

1 B67-43001-289 Handle Adjustment Fitting

36356

10537

mi 2008/1/28

82.0

PB6743001291

Clamp Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp Bushing

Pick: Blade Positioner

Qty Part Number Description

Batch

1 B67-43001-291 Clamp Bushing

36357

mi 2008/1/28

83.0

PB6743001293

Extension Tube Adjustmnt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Extension Tube Adjustmnt

Pick: Blade Positioner

Qty Part Number Description

Batch

1 B67-43001-293 Extension Tube Adjust

36358

10537

mi 2008/1/28

84.0

AN622A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

BOLT

Pick: Blade Positioner

Qty Part Number Description

Batch

1 AN6-22A Bolt

18057

AS 08/01/11

(42)

85.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Pick: Blade Positioner

Qty Part Number Description

Batch

3 AN960JD10 Washer

M105792#

AS 08/01/11

(42)

Date: Friday, 04/01/2008 7:26:06 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FOLD KIT

Job Number: 35372

Part Number: D412695011

Job Number:



Seq. #:

Machine Or Operation:

Description :

86.0

MS27039104

Inventory



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

SCREW

Pick: Blade Positioner

Qty Part Number Description Batch

3 MS21039-1-04 Screw

M18431

AS

08/01/11

(x2)

87.0

MS21042L6

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Pick: Blade Positioner

Qty Part Number Description Batch

1 MS21042L6 Nut (or -6)

M104374

AS

08/01/11

(x2)

88.0

MS27039109

Screw



Comment: Qty.: 7.0000 Each(s)/Unit Total : 14.0000 Each(s)

Screw

Pick: Blade Positioner

Qty Part Number Description Batch

7 MS27039-1-09 Screw

M8912

AS

08/01/11

(x2)

89.0

MS518598

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Pick: Blade Positioner

Qty Part Number Description Batch

2 MS51859-8 Washer

M18854

AS

08/01/11

(x2)

90.0

NAS1149F0316P

WASHER



Comment: Qty.: 7.0000 Each(s)/Unit Total : 14.0000 Each(s)

WASHER

Pick: Blade Positioner

Qty Part Number Description Batch

7 NAS1149F0316P Washer

M17890

AS

08/01/11

(x2)

Date: Friday, 04/01/2008 7:26:06 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FOLD KIT

Job Number: 35372

Part Number: D412695011

Job Number:



Seq. #:

Machine Or Operation:

Description :

91.0

NAS1149F0632P

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)  
WASHER

Pick: Blade Positioner

Qty Part Number Description Batch

2 NAS1149F0632P Washer

Assemble as per Dwg B67-43001-27 pg 4.

M18057

AS

08/01/11

(X1)

92.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



08/01/08 (12)



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/01/08 (2)

93.0

PACKAGING 1

PACKAGING RESOURCE #1



Rev B 8/1/08



(2X)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-695-011

94.0

QC21

FINAL INSPECTION/W/O RELEASE



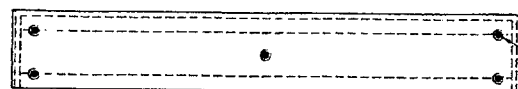
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

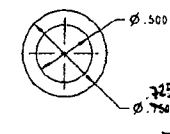


u 08-01-31

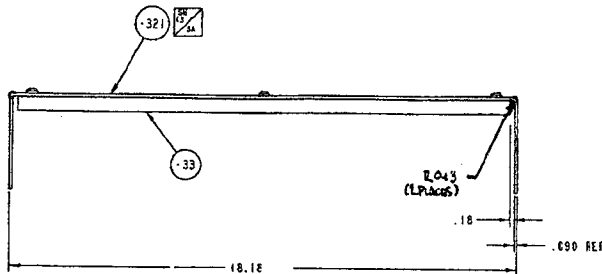
RELEASED  
# 66-01-20



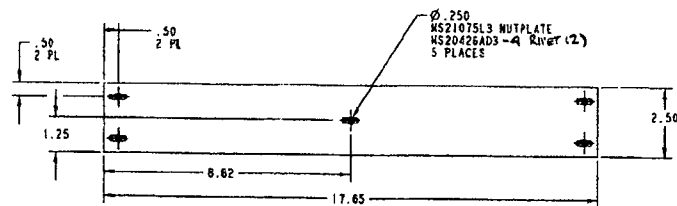
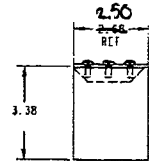
Ø .193 THRU  
MATCH DRILL WITH  
EXISTING NUTPLATE  
LOC'S OF -33  
MS21039-1-09 SCREW  
NAS1149T0316P WASHER  
5 PLACES



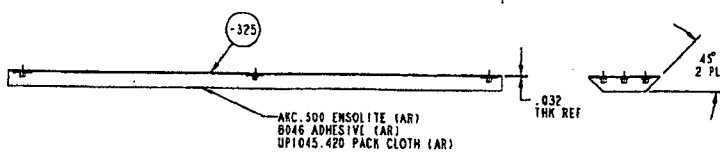
① -299 BUSHING  
SCALE 2.000  
MAT: 304 CRES. COND A



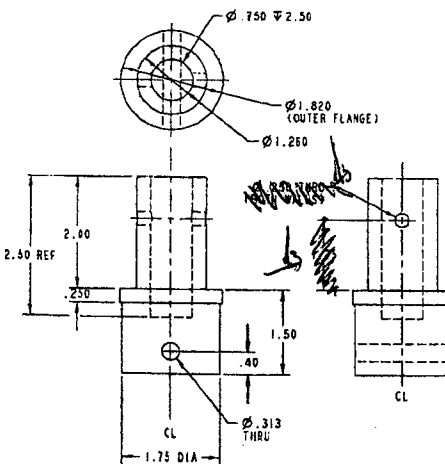
① -31 UPPER RESTRAINT WELDMENT  
SCALE 0.500



Ø .250  
MS21075L3 NUTPLATE  
MS20426AD3-4 RIVET (2)  
5 PLACES



① -33 UPPER PAD ASSY  
SCALE 0.500  
MATL FOR -325: .032 THK 2024-T3 AL.  
00-A-250/4

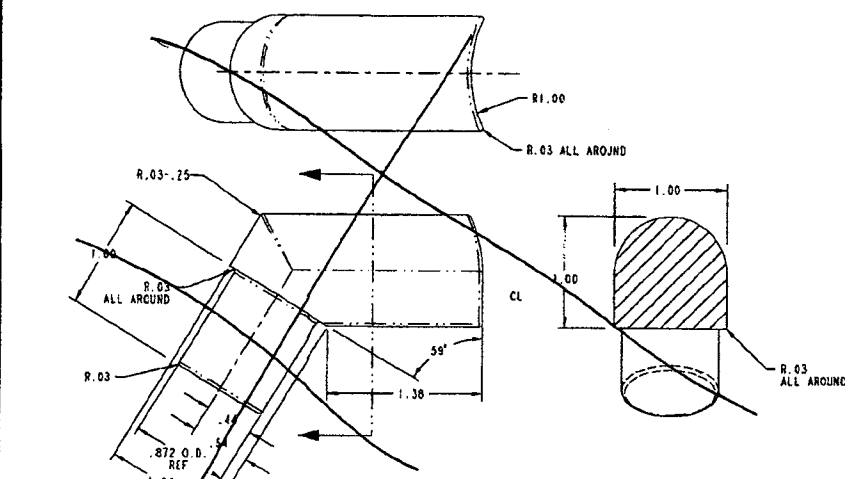


① -305 BEARING  
SCALE 1.000  
MAT: 2024-T3 AL.  
00-A-200/3

PREMIER AVIATION, INC.  
3001 Ardmore Parkway, Grand Prairie, Texas 75002  
D105UV8 B67-43001

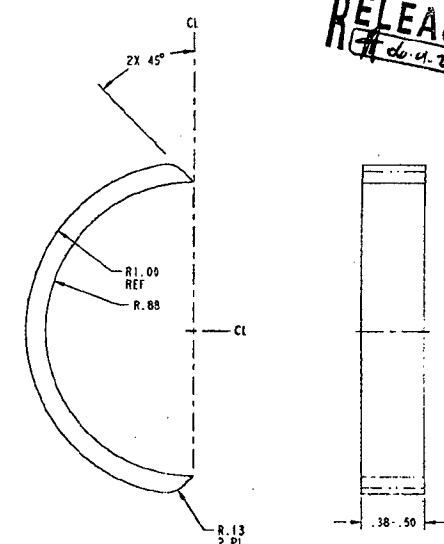
ORIGINAL

**RELEASED**  
11-06-4-20

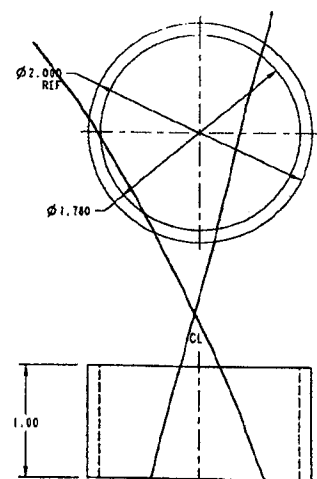


**307 TUBE GUIDE**   
SCALE 2.000  
MAT: 6061-T6 AL  
QQ-A-200/8 OR QQ-A-250/11

**SUPERCEDED BY**  
**D3440-1**



**311 RESTRAINT**   
SCALE 3.000  
MAT: 2.00 O.D. X .125 WALL  
6061-T6 AL, QQ-A-200/8  
OR HW-T-700/6



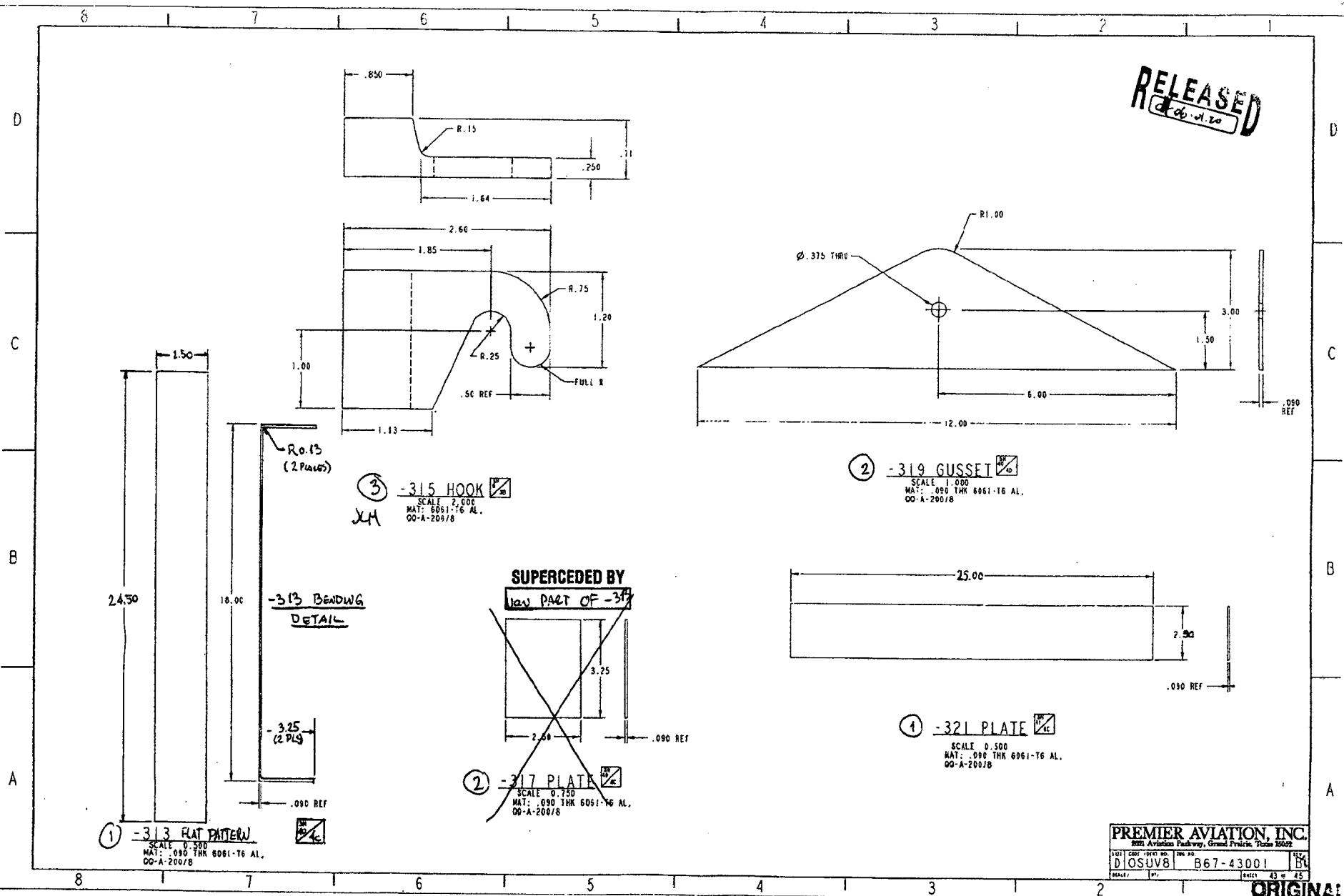
**309 SLEEVE**   
SCALE 2.000  
MAT: 2.00 O.D. X .125 WALL TUBE  
6061-T6, QQ-A-200/8 OR HW-T-700/6

**SUPERCEDED BY**  
**D3440-1**  
**D3440-3**

**PREMIER AVIATION, INC.**  
3080 Aviation Parkway, Grand Prairie, Texas 75052  
SIZE: CORE 1/8" DIA. 1/8" DIA. 1/8" DIA.  
D105UV8 867-43001 81  
SHEET 42 OF 45

**ORIGINAL**

RELEASED  
2006-01-20

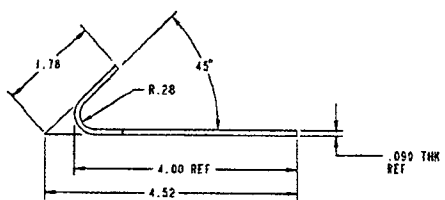
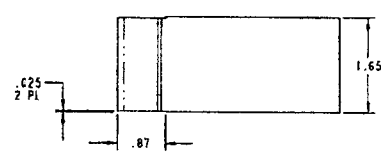


SUPERCEDED BY  
NEW PART OF -317

PREMIER AVIATION, INC.  
8001 Aviation Parkway, Grand Prairie, Texas 75052  
D OSUV8 B67-43001  
SHEET 43 of 45

ORIGINAL

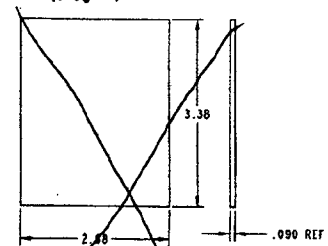
RELEASED  
11-01-20



② -337 SIOP PLATE  
SCALE 1.000  
MAT: .090 THK 6061-T6 AL,  
QQ-A-20078

SUPERCEDED BY

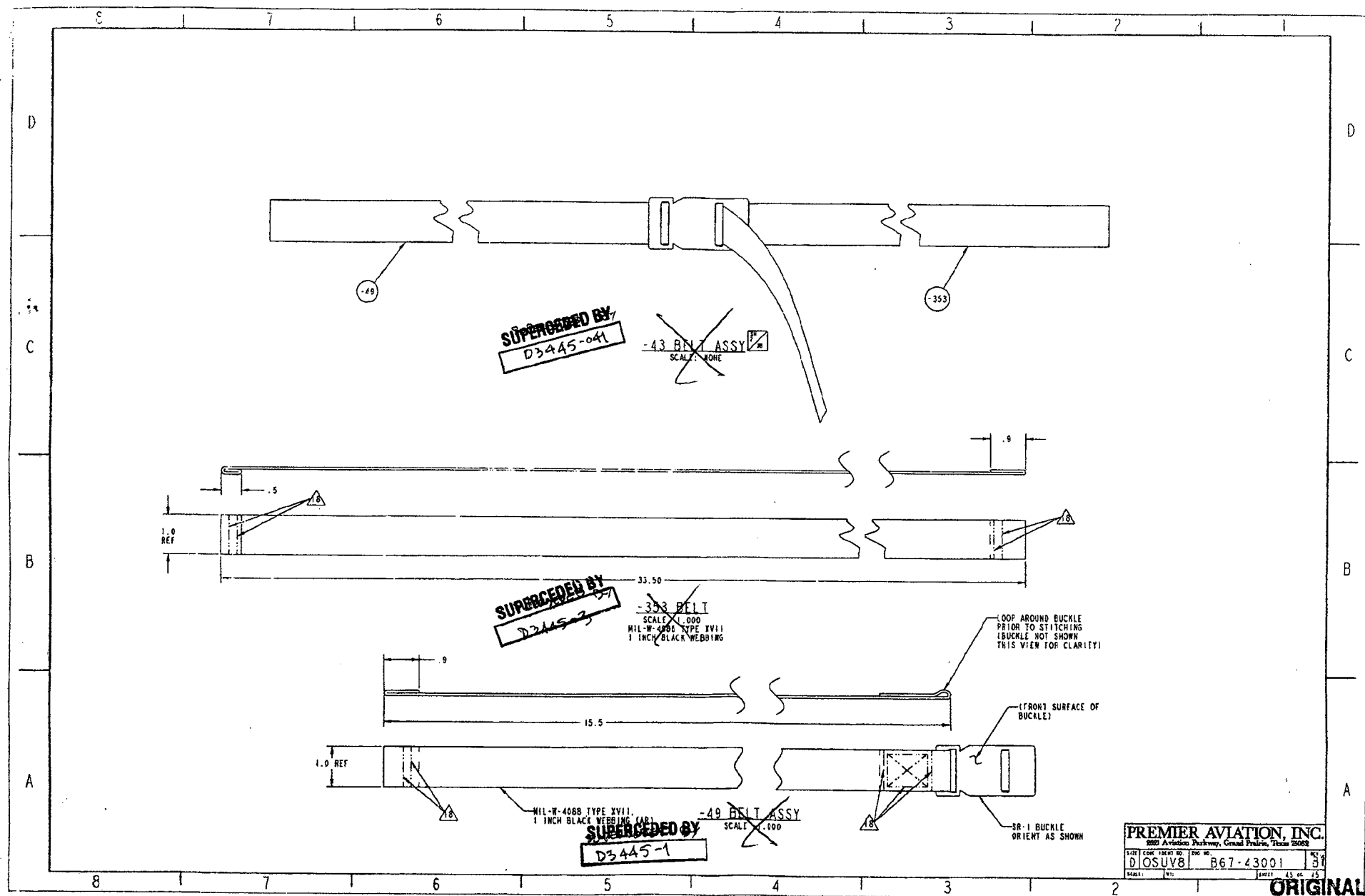
NEW PART OF -324



① -323 PLATE  
SCALE 1.000  
MAT: .090 THK 6061-T6 AL,  
QQ-A-20078

PREMIER AVIATION, INC.  
200 Aviation Parkway, Grand Prairie, Texas 75050  
SIZE CODE PART NO. QD NO. REV.  
D OSUV8 B67-43001 80  
SHEET 44 OF 45

ORIGINAL



PREMIER AVIATION, INC.  
3000 Aviation Parkway, Grand Prairie, Texas 75052

SIZE	CONT	IDENT NO.	REV NO.
D	OSUV8	B67-43001	31
DATE:		BY:	CHECKED BY:
11/11		45	15

ORIGINAL





Date: Monday, 1/28/2008 8:58:44 AM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BLADE FOLD KIT
Job Number	: 35372		
Estimate Number	: 10787		
P.O. Number	:	Part Number	: D412695011
This Issue	: 1/28/2008 S.O. No. :	Drawing Number	: B67-43001 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 10/25/2007 Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	: 29657	Material	:
Written By	:	Due Date	: 12/23/2007 Qty: 2 Um: Each
Checked & Approved By	:		
Comment	: Est A 05.08.30 New Issue KJ/MB/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-695-011 CHG002

08.01.28

2.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING

SANDTEX GREEN PER QSI005

PARTS BELOW WHERE APPLICABLE

3.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
-----	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Job Completion



REFERENCE DR.

Date: \* Wednesday, 30/01/2008 4:25:16 PM  
 User: Dominique Dube

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: BLADE FOLD KIT
<b>Job Number</b>	: 35372		
<b>Estimate Number</b>	: 10787		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D412695011
<b>This Issue</b>	: 30/01/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: B67-43001 REV B
<b>First Issue</b>	: 25/10/2007	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 29657	<b>Drawing Revision</b>	: B
		<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 23/12/2007
<b>Checked &amp; Approved By</b>	:	<b>Qty:</b>	2
<b>Comment</b>	: Est A 05.08.30 New Issue KJ/MB/JLM	<b>Um:</b>	Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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91.0	NAS1149F0632P	WASHER
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Pick: Blade Positioner

Qty	Part Number	Description	Batch
2	NAS1149F0632P	Washer	M18057

Assemble as per Dwg B67-43001-27 pg 4.

08/01/11 (X1)

92.0	D34513	D3451-3
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

D3451-3

B36269 min 2008/1/30 x 2

93.0	D34515	D3451-5
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

D3451-5

B36273 min 2008/1/30 x 2

93.1	PB674300171	PB67-43001-71
------	-------------	---------------



**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

PB67-43001-71

B36795 min 2008/1/30 x 3

93.2	PB674300183	PB67-43001-83
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**Comment:** Qty.: 5.0000 Each(s)/Unit Total : 10.0000 Each(s)

PB67-43001-83

B36264 x 9

B36353 x 1 min 2008/1/30

Date: Wednesday, 30/01/2008 4:25:16 PM  
User: Dominique Dube

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FOLD KIT

Job Number: 35372

Part Number: D412695011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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93.3	PB674300185	PB67-43001-85
------	-------------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
PB67-43001-85

B36351 min 2008/1/30 x 2

93.4	PB6743001155	Pin
------	--------------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Pin

B36354 min 2008/1/30 x 2

93.5	PB6743001267	PB67-43001-267
------	--------------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
PB67-43001-267

B36265 x 1 min 2008/1/30

93.6	PB6743001325	PB67-43001-325
------	--------------	----------------



Comment: Qty.: 1.0000 Each(s)/Order Total : 1.0000 Each(s)  
PB67-43001-325

B3666 B36656 min 2008/1/30 x 1

94.0	D34517	HANDLE & LOCK DOWN ASSY
------	--------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
HANDLE & LOCK DOWN ASSY

B36278 min 2008/1/30 x 1

94.1	PB674300119	PB67-43001-19
------	-------------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
PB67-43001-19

B36355 x 1 min 2008/1/30

94.2	PB674300121	PB67-43001-21
------	-------------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)  
PB67-43001-21

B36258 x 3

B36953 x 1 min 2008/1/30

94.3	PB674300123	PB67-43001-23
------	-------------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)  
PB67-43001-23

B36259 min 2008/1/30 x 4

Date: Wednesday, 30/01/2008 4:25:16 PM  
User: • • Dominique Dube

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FOLD KIT

Job Number: 35372

Part Number: D412695011

Job Number:



Seq. #:

Machine Or Operation:

Description :

94.4

PB674300129

PB67-43001-295



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
PB67-43001-295

B36391 x1 min 2008/1/30

94.5

PB674300131

PB67-43001-31



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
PB67-43001-31

B36349 x1 min 2008/1/30

94.6

PB674300135

PB67-43001-21



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
PB67-43001-21

B36347 x1  
B36260 x1 min 2008/1/30

94.7

PB674300137

PB67-43001-37



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
PB67-43001-37

B36262 min 2008/1/30 x2

94.8

PB674300159

PB67-43001-59



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
PB67-43001-59

B36263 min 2008/1/30 x2

94.9

PB674300167

PB67-43001-67



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
PB67-43001-67

B36796 min 2008/1/30 x2

95.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/01/28 (x2)

96.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-695-011

REV B 08/1/28 (x2)

Date: Wednesday, 30/01/2008 4:25:16 PM

User: Dominique Dube

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FOLD KIT

Job Number: 35372

Part Number: D412695011

Job Number:



Seq. #:

Machine Or Operation:

Description :

97.0

OUTSIDE SERV.15

OUTSIDE SERVICES - LF



Comment: Sub-Contracting OUTSIDE SERVICES - LF

98.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

